

5173848



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6201

Job Sheet 193271



Part No: D6201

Job Qty: 20 ft

Part Name: T Extrusion



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/10/19

Job Tracking No:

Due Date: 4/29/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV A

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
							Workcenter / Supplier Lead Time	
100	Purchasing - Ft	20 ft		4/29/19	0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	20 pcs		4/29/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	

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				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120	QC 6	20 pcs	4/29/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
130	Packaging 3-1 - Stock - B4B	20 pcs	4/29/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
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					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
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					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - SA FT	20 ft	4/29/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - Issue P/O: _____ a)Description: T-beam extrusion b) 4.00" x 4.00" x 0.375" c) Minimum Ultimate Tensile Descriptions: Strength = 38ksi d) Minimum Yield Tensile strength = 35ksi e) Material: 6061-T6/T6511 (QQ-A-200/8) 110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material certification is attached 120 - (QC6- All purchased or subcontracted products) Ensure Material certification comply to Dwg D6201 130 - (Identify as per dwg & Stock Location: _____ LOCATION: MAT028					

PO Details

Acier Ouellette Inc. (aci001-vc)



PO No: PO043180

Line No: 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201P	T Extrusion 4X4X3/8	20 ft (1 ea)	100-Purchasing - Ft	5173845

Job Allocations

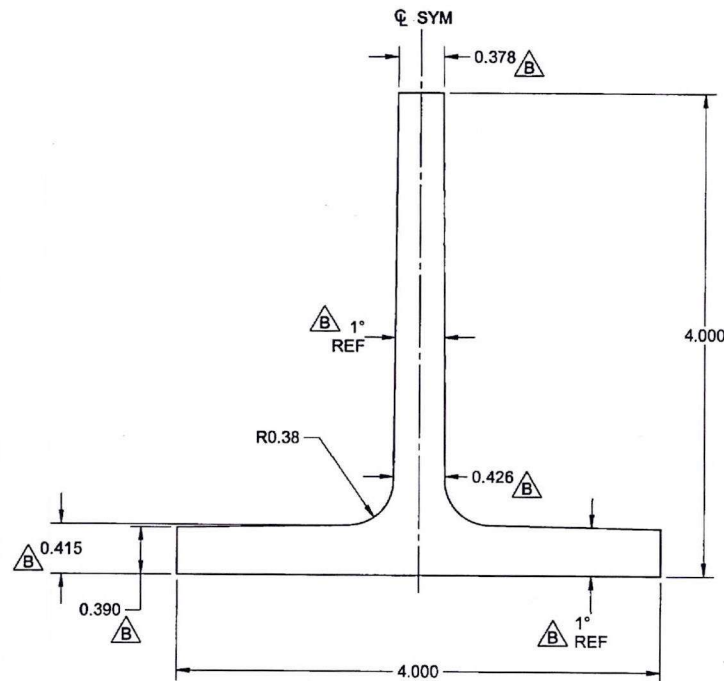
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - Ft	D6201P	20	0	0

Part Specifications

Specifications could not be found.

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SPECIFICATION CONTROL DRAWING



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES
EG. 27 INCHES LONG EXTRUSION: D6201-027

NOTES:

- 1) MATERIAL: ALUMINUM T-EXTRUSION, ROUND FILLET
6061-T6/T6511 PER AMS-QQ-A-200/8 OR QQ-A-200/8 OR ASTM B221
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.67 lb/ft

RELEASED
2017-07-27
EAW 17-660

APPROVED

B	REFORMAT TO CURRENT STANDARDS; 1° TAPERS DEFINED BY 0.378 & 0.426 AND 0.390 & 0.415 WERE NON-TAPERS (0.375). REASON: CAR17-164. UPDATE MATERIAL CALLOUT.	ML	17.06.05
A	NEW ISSUE	CP	01.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO. D6201	
MFG. APPR.	LL	REV. B	
APPROVED	WM	SHEET 1 OF 1	
DE APPR.	CP	SCALE	
DATE	17.06.05	T-BEAM EXTRUSION NTS	
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**ACIER OUELLETTE INC.**

935, Boul. du Hâvre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

DELIVERY - CLIENT**Copy**

CO00141647

Billed to
DART AEROSPACE LTD
1270 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to
1270 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Att : CHANTAL LAVOIE Tél.: 613-632-5200

Delivery Route 5

Customer N° CLI0001056
Date 2019/04/12
Delivery date **2019/04/18**
Your order N° 043180
Processed by Josianne Bourdon
Salesman JOSIANNE BOURDON
Carrier OUELLETTE VALLEYFIELD
Credit Terme Net 30 Days

OK
e-v.

Instruction F-M

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 T-BAR ALU 4 X 4 X 3/8 * D6201 TBAL-4438 6434 1 X 20' PO 043180 LINE 1 HEAT # 852198 AC25292-MGR-15/04	68.60	20.00	PI_\$CLB								
		1.00	UN_\$UN								
Note : ATTENTION: MILL TEST REQUIS Chaque item identifier avec : - Le # PO client - Le # d'item - Le heat # - Emballer les pièces dans carton											

Conditions :

All sold and delivered materials remain the property of "Acier Ouellette Inc" until payment is made in full, complete and cashed. All lost materials are at the buyer's expense. The warranty offered by "Acier Ouellette Inc." is the same as offered and honored by the manufacturer and his warranty is transferred by "Acier Ouellette Inc." to the client. The buyer hereby accepts to respect the following conditions: Net 30 days from billing date and the buyer accepts to pay administration charges of 2% per month (24% per annum) on all past due amounts over 30 days. Any default in respect with this contract will lead to payment by acceleration and permits to the seller, at his choice to claim for the balance due or the repossession of the goods sold. All claims must be made within five (5) days with this document enclosed. Any merchandise that has been damaged, cut or modified cannot be returned. All goods returned must be with our authorization and are subject to a 25% restocking charge.

Total Weight (Lbs) : 68.60**NIR : R-109516-6**

Prepared By :

Verified By :

Delivered By :

Time

Customer's Signature

Date

Y M D
19 04 18

25292 N
C129820

CERTIFICATE OF COMPLIANCE

05/31/2015	5367009	118419	1
PO37565	020743	852198 <i>founder</i>	05/31/15

002	C-031522-10	240" MILL 6061 T6511	3/8X4X4" TEE ALUMINUM
774 LBS			
752 LBS		11 PCS	1 PKGS

ASTM B221-08	
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Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
334.5 / 48.5	304.2 / 44.1	15.4	N/A	92

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.60	0.24	0.19	0.06	0.87	0.06	0.06	0.02	0.01	0.00

This Material is Made in Canada
This Material is RoHS Compliant

Heat: 852198

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/T316949 Registered Company

Visit us at www.signaturealum.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 16201
DATE: 19/04/25

PO / BATCH NO.: P0043180/5173848

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 2051
QUANTITY INSPECTED: 2051
QUANTITY REJECTED: 0

THICKNESS ORDERED: 4"
THICKNESS RECEIVED: 4"
SHEET SIZE ORDERED: —
SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	<u>ASTM B211</u>
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	<u>HT-852198</u>
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>61</u> DATE: <u>APR 25 2019</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in